

Date: Thursday, 2/1/2007 9:04:23 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 ASPIRATOR ASSEMBLY
Job Number	: 30567 - 1		
Estimate Number	: 11834		
P.O. Number	: N/A	Part Number	: D2306
This Issue	: 2/1/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2306 REV C
First Issue	: 1/31/2007	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: C
		Material	: N/A
Written By	: <u>                    </u>	Due Date	: 3/15/2007
Checked & Approved By	: <u>                    </u> 07.02.01	Qty:	1 Um: Each
Comment	: Est. A 98.09.10 New KS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D22891	Mounting Brkt, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Mounting Brkt, LH

Qty	Part Number	Description	Batch No.
1	D2289-1	Valve Mounting Brkt	B3847

2.0	D22892	Mounting Brkt, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Mounting Brkt, RH

Qty	Part Number	Description	Batch No.
1	D2289-2	Valve Mounting Brkt	B3847

3.0	D2295	Heater Outer Skin
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Heater Outer Skin

Qty	Part Number	Description	Batch No.
1	D2295	Exterior Sheet	B3840 001

4.0	D2294	Perforated sheet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Perforated sheet

Qty	Part Number	Description	Batch No.
1	D2294	Perforated Sheet	B30578



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 ASPIRATOR ASSEMBLY

Job Number: 30567

Part Number: D2306

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2301

Insulation Filter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Insulation Filter

Qty Part Number

Description

Batch No.

1 D2301

Insulation Filter

~~B17044~~ B 30572-1

6.0

D2302

Intake Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Intake Weldment

Qty Part Number

Description

Batch No.

1 D2302

Intake Assembly

B 30581

7.0

D2303

Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Outlet Weldment

Qty Part Number

Description

Batch No.

1 D2303

Outlet Assembly

B 30582

8.0

D2317

Valve Mtg Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Valve Mtg Bracket

Qty Part Number

Description

Batch No.

1 D2317

Valve Mounting Brkt

B 4744

9.0

D2334

Control Cable Mounting B



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Control Cable Mounting B

Qty Part Number

Description

Batch No.

1 D2334

Control Cable

B 3841A

10.0

D2342

Heater Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Bracket

Qty Part Number

Description

Batch No.

1 D2342

Mounting Channel

B 30583

N



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Process Sheet

355 x12 275 x4

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 ASPIRATOR ASSEMBLY

Job Number: 30567

Part Number: D2306

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2375416163

Insulation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Insulation

Qty Part Number Description  
1 D2375-4-16-163 Insulation

Batch No.

M1810

12.0

AN33A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Qty Part Number Description  
4 AN3-3A Bolt

Batch No.

M102380

13.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Qty Part Number Description  
8 AN960JD10 Washer

Batch No.

M100274

14.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Blind Rivet

Qty Part Number Description  
7 MS20600AD4W5 Rivet  
(or CR9163-4-5)

Batch No.

M7209

15.0

MS20600AD4W6

Rivet



Comment: Qty.: 23.0000 Each(s)/Unit Total : 92.0000 Each(s)

Rivet

Qty Part Number Description  
23 MS20600AD4W6 Rivet  
(or CR9163-4-6)

Batch No.

M8325x36

M103481x56

16.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet, Universal Head

Qty Part Number Description  
6 MS20470AD46 Rivet

Batch No.

M18615

PTO



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		MS 20600 AD4W2	MH343	B	07-03-27	12	B	B
		MS 20600 AD4W4	MH3481					
		MS 20470 AD4-5		B	07-03-27	8	B	B

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

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Job Number: 30567

Part Number: D2306

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Qty Part Number Description

4 MS21042L3 Nut

Batch No.

M102217

(or MS21042-3)

18.0

NAS1329A3K80

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Insert

Qty Part Number Description

2 NAS1329A3K80 Insert

Batch No.

M9662

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg. D2306

02.03.29

PTO

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP D204-575-011

B30517

07/3/30

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.03.30



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-03-20	19b	Powder Coat white as per QSI 5 4.3	fel	07/03/20	1	1/20/20	07/03/20
07-03-20	19c	Inspect level 3	1/20/20	07/03/20	1	1/20/20	07/03/20

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED	APPROVED	D2306	SHEET 1 OF 2
DATE	TITLE		
95.01.03	B204 ASPIRATOR ASSEMBLY		
B	Apr. 13, 1995	REVISED D2317	
C	96.01.19	ADDED DETAIL	

QTY	Part No.	Description
X	D2306	B204 ASPIRATOR ASSEMBLY
1	D2302	INTAKE WELDMENT ASSEMBLY
1	D2303	OUTLET WELDMENT ASSEMBLY
1	D2295	HEATER EXTERIOR SHEET
1	D2375-4-16-163	INSULATION
1	D2301	INSULATION FILTER
1	D2294	HEATER PERFORATED SHEET
1	D2289-1	VALVE MOUNTING BRACKET
1	D2289-2	VALVE MOUNTING BRACKET
1	D2317	VALVE MOUNTING BRACKET
1	D2334	CONTROL CABLE SUPPORT
1	D2342	MOUNTING CHANNEL
4	AN3-3A	BOLT
8	AN960JD10	WASHER
7	MS20600AD4W5	RIVETS CR9163-4-2
23	MS20600AD4W6	RIVETS CR9163-4-4
6	MS20470AD4-6	RIVETS
4	MS21042L3	NUTS
2	NAS1329A3K80	RIVNUTS

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WORK ORDER  
NO. 30567





DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED B.W.	APPROVED B.W.	
DATE 95.01.03	TITLE B204 ASPIRATOR ASSEMBLY	REV. C SHEET 2 OF 2 SCALE





